

Ship today 19/05

Work Order ID 58891

May 19, 2010 11:32:15 AM



Page 1

Item ID: D3121-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 5/19/10

Start Qty: 5.00



Cust Item ID:

Required Date: 5/19/10

Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn D3121-25 Cap as per Folio FA387□2-Deburr

SA 10/05/19

5 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 10/05/19

5 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SA 10/05/19

5 0

\_\_\_\_\_

Page 2

[illegible]**Setup Start**[illegible]

**Stop**

[illegible]

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

Run Start

[illegible]

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

[illegible]

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

[illegible]

## Small Fab

## Small Fab

## Memo

0.00

## Small Fab

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

SA 10105/19

140

**Abstract**

QC5- Inspect part completeness to step on W/O

0.00

QC

## Memo

0.00

## Quality Control

150

\_\_\_\_\_

Identify as per dwg & Stock Location:

0.00

## Packaging

## Memo

0.00

## Packaging

**Work Order ID 58891**

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Page 3

Item ID: D3121-241

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearing Assembly

Start Date: 5/19/10 Start Qty: 5.00



Cust Item ID:

Required Date: 5/19/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/19

MK

10-5-19

# Picklist Print

May 19, 2010 11:32:13 AM

Page 1

Work Order ID: 58891

Parent Item: D3121-241

Parent Item Name: Bearing Assembly

Comments: IPP Rev:A 04.02.18 New issue KJ/DS  
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Start Date: 5/19/10

Required Date: 5/19/10

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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D3121-23

Manufactured

No

100

Each

42.0000

1



Bearing

Location

Loc Qty

Loc Code

ST235

42

56591

42

No

f

9.3500

MDELNR1.000

Purchased



Delrin Round Bar 1"

Location

Loc Qty

Loc Code

MAT050

9.35

108804

9.35

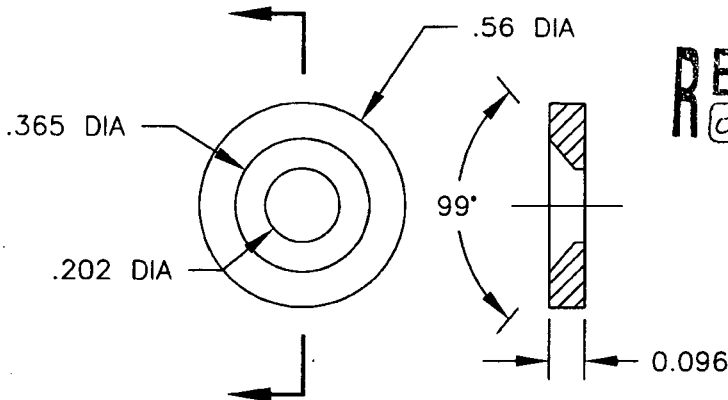
5 5/19/10

.2 5/19/10

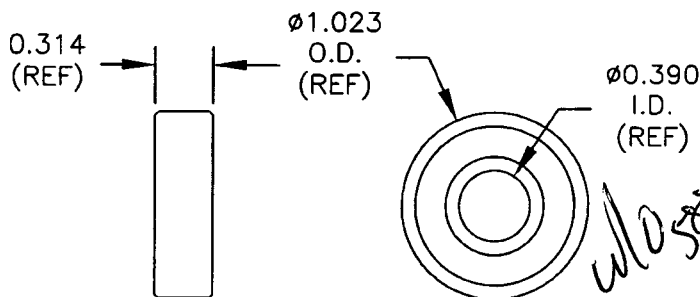


**DART**

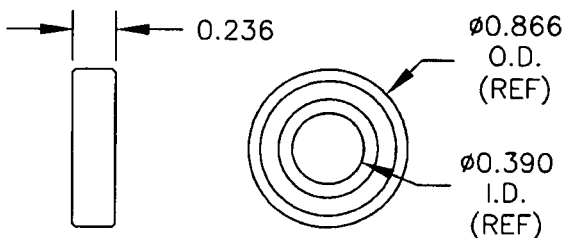
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

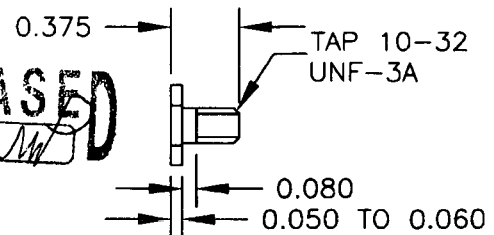
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

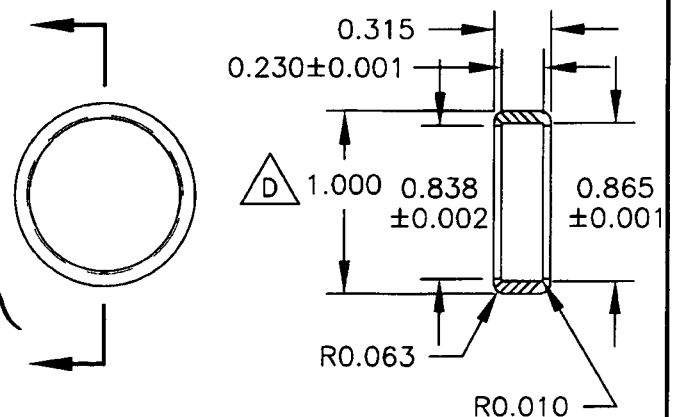
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

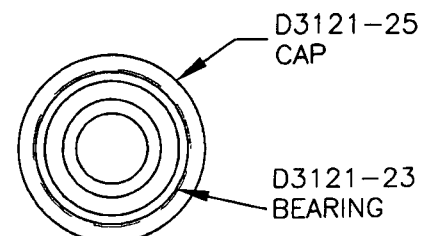
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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